Work Orde Monday, Novem				*762	236*							Page 1
Item ID: Revision ID:	D3492-3			Accept	*N900	040	100	)*	Setup	Start Stop	1 71	S1*
	Plug	C O	*40*							осор	*N.	S2*
Start Date: Required Date:	11/7/2011 : 11/16/2011	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00	*40* *40*		Cust Item Customer:							
Reference:									Run	Start		4.5
Approvals:	Process Pla	nn:	Date: <u>[/-//-07</u>			ate:				Stop	*N	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:					^N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			-							
D3492	D											•
*100*		Hardinge CNC LATHE S	SMALL	0.00				40	0			SJ 1/11/24
Hardinge Hardinge CNC Lath	ne Small .	Memo 1-Turn as pe Dwg Rev: Folio Rev:_	r Folio FA632 & Dwg D349	0.00					-			
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								11 11-11
*110* QC Quality Control		Мето		0.00				40				SI u/u/24
120		QC8- Inspect parts - seco	nd check	0.00						/		
*120* QC Quality Control		Мето		0.00	PP 11.1	(1.2	<del>'/</del>	40	\$			

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			14	ORK ORDER CHANG	CEC					
DATE	STEP	PRO	OCEDURE CH		GES	Ву	Date	Qty	Approval Chief Eng /	Approval
<del>-</del>	-						<del></del>	,	Prod Mgr	QC Inspector
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Part No	•	PAR #:	Foult Col		NC	B. Voc. I	Va DO	١	Data	I
rait NO										
	Re	esolution:							Date:	
NCR:		•	WORK ORI	DER NON-CONFORM	ANCE	(NCR	)			
DATE	CTED	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
									. :	
								:		

Work Order ID 76236 \*76236\* Page 2 Monday, November 07, 2011 2:45:48 PM D3492-3 Accept Item ID: \*N900040100\* Setup Start **Revision ID:** Item Name: Plug \*40\* **Start Qty: 40.00** 11/7/2011 **Start Date: Cust Item ID:** Customer: Req'd Qty: 40.00 **Required Date: 11/16/2011** \*40\* Reference: Run Tooling: Date: Date: Process Plan: Approvals: Date: **SPC (Y/N):** Date: OC: Reject Insp. Tool ID Tool # Plan Reject Sequence ID/ **Operation** Set Up/ Accept Qty Number Stamp Code **Qty** Work Center ID Description **Run Hours** Chemical Conversion Coat per QSI005 4.1 0.00 130 \*130\* 0.00 HandFinish Memo Hand Finishing White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 140 \*140\* Powdercoat Memo (Flat End Only) Powder Coating START TIME: OVEN TEMPERATURE FINISH TIME: QC3- Inspect Part Finish 0.00 150

\*150\* QC

Quality Control

Memo

0.00

40 BR 11-12-1.

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES		- · · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	solution:	Disposition	:	_ QA: N/C (	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Description	ion B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
							****		

Work Orde				*762	236*				Page 3
Item ID: Revision ID: Item Name:	D3492-3 Plug			Accept	*N900040	100*	Setup S	~.	NS1* NS2*
Start Date: Required Date: Reference:	11/7/2011	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00	*40* *40*		Cust Item ID: Customer:				
Approvals:	Process Plan	:	Date:	Tooling: SPC (Y/N):	Date:			Start *	NR1* NR2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ck Location: F-P	Set Up/ Run Hours	Tool ID Tool #	Plan Acce Code Qty	pt Rejec Qty	t Rejec	_
*160* Packaging Packaging		Мето		0.00		40 X	J-44		41/12/01
170		QC21- Final Inspection -	Work Order Release	0.00				11/1	2 6 A
*170*		Memo		0.00				<u> </u>	- (-1)

Quality Control

/ 1512-05

Dart Aerospace	Ltd	
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	1								<u></u>	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>4</b> :	_ Date: _		
	Re	esolution:	Dispositio	n:	_ QA: N/C Cld	osed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	)				
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector	
						1.				

**Picklist Print** 

Monday, November 07, 2011 2:45:53 PM

Work Order ID: 76236

\*76236\*

Parent Item:

D3492-3

\*D3492-3\*

Parent Item Name: Plug

**Start Date:** 11/7/2011

**Required Date:** 11/16/2011

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No		100	f	37.8280	0.06	2.526316			0 1 1
*M6061T6	SP0 750	*						**	2.485	1	A	1 wulz

6061-T6 Round Bar .750"

<b>Location</b>	Loc Qty	Loc Code	
MAT013.	37.828		
112442	0.796		
117481	1.969		
118106	1.338		
119231	33.725		2.4851

W/O:			W	ORK ORDER CHANG	iES					
DATE	STEP	PR	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-							
·										
		·				:			:	
Part No			Fault Cate	egory:	NCI	R: Yes	No <b>DQ</b>	<b>4</b> :	_ Date: _	
	Re	esolution:	Disposition	on:	_ QA:	N/C CI	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR	)			
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
		-		·						
		<b>*</b> * .								

DART AEROSPACE LTD	Work Order:	14236
Description: Plug	Part Number:	D3492-3
Inspection Dwg: D3492 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	\$0.750	V		5L08 5402	
Ø0.582	+0.008/-0.001	\$0.582	<b>V</b>		u	
0.045	+0.000/-0.002	0.0445		-	e.	
0.060	+/-0.005	0.0605	1		ų	
0.060	+/-0.005	0.000			vi	
0.500	+/-0.010	0.500		ì	vi	
0.090	+0.000/-0.002	0.089	<b>V</b>		· · ·	
	·					
·						

Measured by:	St.	Audited by:	Re	Preliminary Approval:	
Date:	11/11/29	Date:	11.11.24	Date:	

Rev	Date	Change	Revised by	Approved
Α	06.07.07	New Issue P/O D3492-043	KJ/JLM	
В	06.10.16	Ø0.750 was Ø0.625	KJ/JLM	
С	08.09.04	Tolerance revised for Ø0.750	KJ/DD .∧	
D	11.06.21	Dwg Rev updated	KJ OV (	ZII
				7-1

W/O:			WC	ORK ORDER CHANG	ES	***************************************				
DATE	STEP	PF	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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					f					
						,				
			19-14-4-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-							
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					
Resolution:			Disposition	n:	QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR	)				
DATE	STEP	Description of NC		Corrective Action Secti		Verification		Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector		
	:									
								:		

D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

### **D3492-XXX PLUG PARTS LIST**

QTY -041	Q1Y -043	QTY -045	QTY -047	QTY -049	QTY -051	Q1Y -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	Х						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			Х				D3492-047	PLUG ASSEMBLY
				Х			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
	1					1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
					-	1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

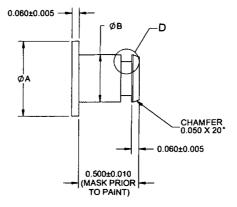
SHOP CUEY RETURN (C) ENGINE PROPERTY UNCONTROLEMAN WOEK WOEK NO. — LEASED 2011-05-30

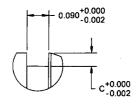
DESIGN PH		PH	DART AEROSP	ACE L	D
REV.	DESCRI	PTION		BY	DATE
Ā	NEW ISS	SUE		PH	06.01.04
В	ADD -04	7; UPDATE DIM A	FOR -045	PH	08.05.11
С	ADD -04	9/-051/-053, CHAN	PH	07.10.05	
D	WAS 0.0	ORATED DEO D3 55. (SEE CAR11-0	AJS	11.05.24	

DESIGN	PH	■ DART AERO	SPACE LTD
DRAWN	AIS	HAWKESBURY, O	NTARIO, CANADA
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APPROVED	1/2/	TITLE	SCALE
DE APPR.	78	PLUG	2:1
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W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE	ı.	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	-						<del></del>			
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Part No	:	PAR #:	Fault Cate	jory:	NCR:	Yes 1	lo DQA	<b>\:</b>	Date:	
			Disposition: QA			QA: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORM	IANCE (	NCR)	)			
DATE	STEP	Description of NC	Corrective Action Section B			Verificat				Approval
DAIL	SILF	Section A	Initial Chief Eng			Sign & Date		Section C		QC Inspector

-POWDER COAT THESE FACES ONLY PER NOTE 2





**DETAIL D** 

**D3492-XX PLUG** 

#### **D3492-XX PLUG MACHINING DETAILS**

P/N	A	В	С	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

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DESIGN	PH	DART AERO	DART AEROSPACE LTD				
DRAWN	AJS	HAWKESBURY, OF	NTARIO, CANADA				
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MFG. APPR.	JESA	D3492	SHEET 2 OF 2				
APPROVED	T VAIT	TITLE	SCALE				
DE APPR.	-#-	PLUG	4:1				
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W/O:			W	ORK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _				
Resolution:			Dispositio	n:	_ QA: N/C Cld	QA: N/C Closed: Date:					
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NCR	)					
DATE	0.750	Description of NC	Corrective Action Section			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector			
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